

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013434**Date Inspected:** 23-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	William Sherwood and Bernie Do			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	Orthotropic Box Girder		

**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG L2E/L3E deck plate 'A' inside, QA randomly observed ABF/JV qualified welder Chun Fai Tsui ID # 3426 perform overhead termination welding from one end of backing bar to edge plate 'F'. The welder was observed welding in the overhead (4F) position using Shielded Metal Arc Welding with E7018H4R, 1/8" diameter electrode. The welding being made is a termination and connection from one end of the deck plate 'A' backing bar to the edge plate 'F' in reference to Request For Information (RFI) ABF-RFI-002097R00 dated March 19, 2010. The termination welding on this location was monitored by ABF QC William Sherwood. At the end of the shift, welding was not completed.

At OBG L2E/L3E edge plate 'B' (bottom corner), QA also randomly observed ABF/JV qualified welder James Zhen ID #6001 perform CJP welding of the splice butt joint and tied it into the 'C' plate. The welder was observed welding in the overhead (2G) position using Shielded Metal Arc Welding with E7018H4R, 1/8" diameter electrode. The welding on this location was monitored by ABF QC Barry Drake and was still continuing at the end of the shift.

At OBG L2E/L3E side plate 'C' inside, ABF welder Rick Clayborn and his helper were seen excavating Ultrasonic Testing (UT) detected weld defects on the splice butt joint. The welder and his helper were using a die grinder and a disc grinder to excavate the repairs and were forming the excavations into boat shape. The

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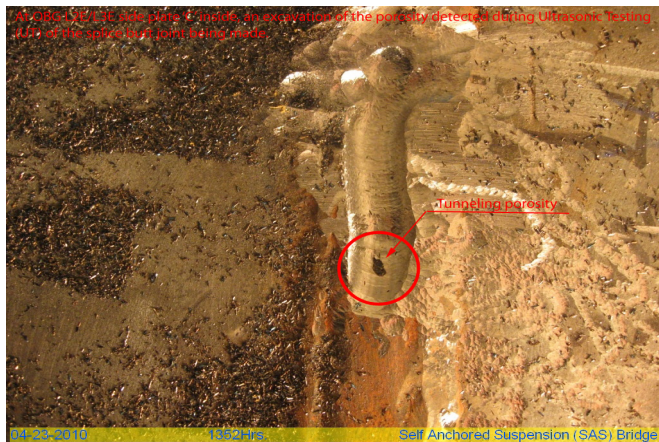
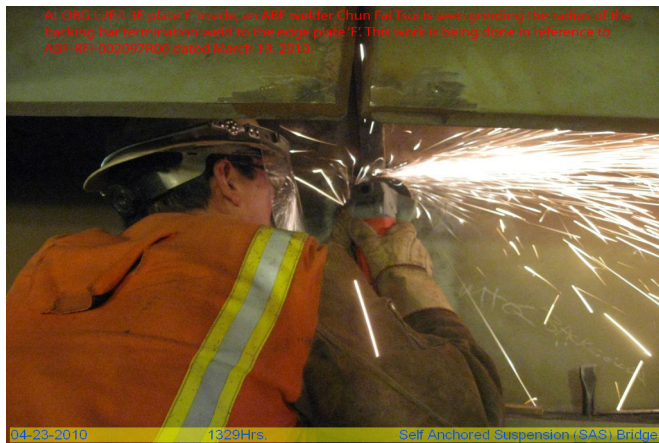
# WELDING INSPECTION REPORT

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excavations were still ongoing and there were no welding performed on the joint during the shift. ABF QC Bernie Docena was noted monitoring the excavations of the UT repairs.

At OBG L3E/L4E side plate 'E' outside, ABF welders Rory Hogan and Jeremy Dolman were seen preparing their welding equipment in preparation for the back welding of the splice butt joint in this location. The back gouged and ground groove areas of the joint were also noted tested using the Magnetic Particle Testing (MT).



## Summary of Conversations:

As stated above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Mohammad Fatemi (916) 227-5298, who represents the Office of Structural Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer